DEPARTMENT OF TRANSPORTATION
DIVISION OF ENGINEERING SERVICES
Office of Structural Materials
Quality Assurance and Source Inspection

Bay Area Branch
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Contract #: 04-0120F4
Cty: SF/ALA Rte: 80 PM: 13.2/13.9
File #: 69.28

WELDING INSPECTION REPORT

Resident Engineer: Pursell, Gary
Address: 333 Burma Road
City: Oakland, CA 94607

Report No: WIR-016067
Date Inspected: 06-Aug-2010

Project Name: SAS Superstructure
Prime Contractor: American Bridge/Fluor Enterprises, a JV
Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island

OSM Arrival Time: 700
OSM Departure Time: 1900
Location: Shanghai, China

CWI Name:	N/a			**CWI Present:**	☐ Yes	☑ No	
Inspected CWI report:	☐ Yes	☐ No	☑ N/A	**Rod Oven in Use:**	☐ Yes	☐ No	☑ N/A
Electrode to specification:	☐ Yes	☐ No	☑ N/A	**Weld Procedures Followed:**	☐ Yes	☐ No	☑ N/A
Qualified Welders:	☐ Yes	☐ No	☑ N/A	**Verified Joint Fit-up:**	☐ Yes	☐ No	☑ N/A
Approved Drawings:	☐ Yes	☐ No	☑ N/A	**Approved WPS:**	☐ Yes	☐ No	☑ N/A
				Delayed / Cancelled:	☐ Yes	☑ No	☐ N/A

Bridge No: 34-0006
Component: OBG Trial Assembly

Summary of Items Observed:

On this date Caltrans OSM Quality Assurance (QA) Inspector Mr. S. Manjunath Math was present during the time noted above for observations relative to the work being performed.

This QA Inspector randomly observed the following work in progress:

Orthotropic Box Girder (OBG) Trial Assembly Areas

Segment 9DW to Segment 9EW

This QA Inspector performed Dimension Control Inspection for measuring Offset along with ABF QA personnel on the U-Rib to U-Rib from Counter Weight side to Cross Beam side at a total of 39 locations on Segment 9CW to Segment 9DW between Panel Point (PP) 82 to PP 83 at the following locations:

The offset was measured within 50mm from the Deck Panel on U-Rib on the South and North side. The QA Inspector measured the Offset using 1(One) Meter Straight Edge.

The measurements were recorded in the Dimension Control Plan (DCP) on a separate form and submitted to the Lead Inspector and Engineer for review and disposition.

Segment 9DE to Segment 9EE

This QA Inspector performed Dimension Control Inspection for measuring Offset and Sweep along with ABF QA personnel on the Longitudinal Diaphragm to Longitudinal Diaphragm at Work Point E3 (Bike Path side) and E4 (Cross Beam side) for the Segment 9DE to Segment 9EE between Panel Point (PP) 82 to PP 83 at the following locations:

The offset was measured at 5 (five) different locations in which 2 (Two) locations were at Flange area and 3 (Three) locations were at Web area. The QA Inspector measured the Offset using 1(One) Meter Straight Edge.

The Sweep was measured at 100 mm from both sides of the Floor Beam and 800mm from both sides of floor Beam and at Center (Total 5 Locations) using string line.

The measurements were recorded in the Dimension Control Plan (DCP) on a separate form and submitted to the Lead Inspector and Engineer for review and disposition.

Segment 9DW

This QA Inspector performed Dimension Control Inspection along with ABF QA personnel for the Segment 9DW from Panel Point (PP) 80 at the following locations after heat straightening the out of tolerance area:

The Floor Beam (FB) flatness was verified and measured from East and West side of the FB at Panel Points (PP) 80. The QA Inspector measured the flatness using 1500mm Straight Edge.

The measurements were recorded in the Dimension Control Plan (DCP) on a separate form and submitted to the Lead Inspector and Engineer for review and disposition.

Segment 9CE

This QA Inspector performed Dimension Control Inspection along with ABF QA personnel for the Segment 9CE from Panel Point (PP) 77, PP 78 and PP 79 at the following locations after heat straightening the out of tolerance area:

The Deck Panel to the Deck Panel Diaphragm plate plumbness was verified and measured from east and west side of the Deck Panel Diaphragm at Panel Points (PP) 77, 78 and PP 79. The QA Inspector measured the plumbness using carpenter square.

The measurements were recorded in the Dimension Control Plan (DCP) on a separate form and submitted to the Lead Inspector and Engineer for review and disposition.

Segment 9DE

This QA Inspector performed Dimension Control Inspection along with ABF QA personnel for the Segment 9DE from Panel Point (PP) 80, PP 81 and PP 82 at the following locations after heat straightening the out of tolerance area:

The Deck Panel to the Deck Panel Diaphragm plate plumbness was verified and measured from east and west side of the Deck Panel Diaphragm at Panel Points (PP) 80, 81 and PP 82. The QA Inspector measured the plumbness using carpenter square.

The measurements were recorded in the Dimension Control Plan (DCP) on a separate form and submitted to the Lead Inspector and Engineer for review and disposition.

Segment 9BW

This QA Inspector performed Dimension Control Inspection along with ABF QA personnel for the Segment 9BW from Panel Point (PP) 74, PP 75 and PP 76 at the following locations after heat straightening the out of tolerance area:

The Deck Panel to the Deck Panel Diaphragm plate plumbness was verified and measured from east and west side of the Deck Panel Diaphragm at Panel Points (PP) 74, 75 and PP 76. The QA Inspector measured the plumbness using carpenter square.

The measurements were recorded in the Dimension Control Plan (DCP) on a separate form and submitted to the Lead Inspector and Engineer for review and disposition.

Segment 9CW

This QA Inspector performed Dimension Control Inspection along with ABF QA personnel for the Segment 9CW from Panel Point (PP) 77, PP 78 and PP 79 at the following locations after heat straightening the out of tolerance area:

The Deck Panel to the Deck Panel Diaphragm plate plumbness was verified and measured from east and west side of the Deck Panel Diaphragm at Panel Points (PP) 77, 78 and PP 79. The QA Inspector measured the plumbness using carpenter square.

The measurements were recorded in the Dimension Control Plan (DCP) on a separate form and submitted to the Lead Inspector and Engineer for review and disposition.

Segment 9DW

This QA Inspector performed Dimension Control Inspection along with ABF QA personnel for the Segment 9DW from Panel Point (PP) 80, PP 81 and PP 82 at the following locations after heat straightening the out of tolerance area:

The Deck Panel to the Deck Panel Diaphragm plate plumbness was verified and measured from east and west side of the Deck Panel Diaphragm at Panel Points (PP) 80, 81 and PP 82. The QA Inspector measured the plumbness using carpenter square.

The measurements were recorded in the Dimension Control Plan (DCP) on a separate form and submitted to the

Lead Inspector and Engineer for review and disposition.

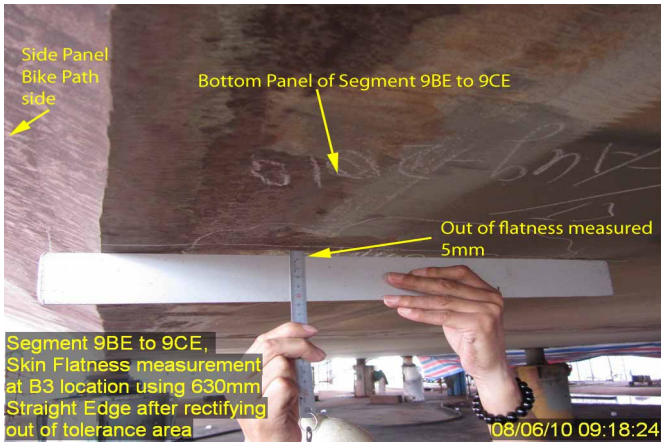
Segment 9BE to Segment 9CE (Skin Flatness)

This QA Inspector performed Joint Inspection along with ABF QA personnel at out of tolerance area after rectification to check the Skin Flatness between Segment 9BE to Segment 9CE between Panel Points (PP) 76 and PP 77 at the following locations:

The skin flatness was measured on South side (Bike Path side at B3 location) from the weld connecting Bottom Panel to Side Panel using Straight Edges of 630 mm of length and observed dimension in general compliance.

The measurements were recorded in the Dimension Control Plan (DCP) on a separate form and submitted to the Lead Inspector and Engineer for review and disposition. Please reference the pictures attached for more comprehensive details.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

No relevant conversations were reported on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Math,Manjunath	Quality Assurance Inspector
Reviewed By:	Peterson,Art	QA Reviewer